

Work Order ID 130534

130534

Friday, March 13, 2015 1:00:20 PM

Page 1

Item ID: D3793-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft
 Start Date: 3/13/2015 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-03-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3793	Rev A

100 FLOW WATER JET 0.00 ***100*** 24 0 Jm15-3-15
 Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D3793
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00 ***110*** 24 0 Jm15-3-15
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00 ***120*** 24 15-03-16
 QC Memo 0.00
 Quality Control

DAS
9
9-89

Work Order ID 130534

Friday, March 13, 2015 1:00:20 PM

130534

Page 3

Item ID: D3793-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Aft
Start Date: 3/13/2015 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

(24)

DAS
38
0.00

MAR 20 2015

170

Identify as per dwg & Stock Location: FP-002 0.00***170***

Packaging

Memo

0.00

Packaging

x24 d 911 15/03/13

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

MLS 15-03-23

MF
15-3-23

Picklist Print

Friday, March 13, 2015 1:00:23 PM

Page 1

Work Order ID: 130534

130534

Parent Item: D3793-3

D3793-3

Parent Item Name: Wearplate Aft

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	343.7123	1.2828	22			

M304S20GA

304/316 .040 Sheet

Jm 15-3-15.

Location

Loc Qty

Loc Code

MAT

212.6

m131700

212.6

MAT020

131.1123

m130345

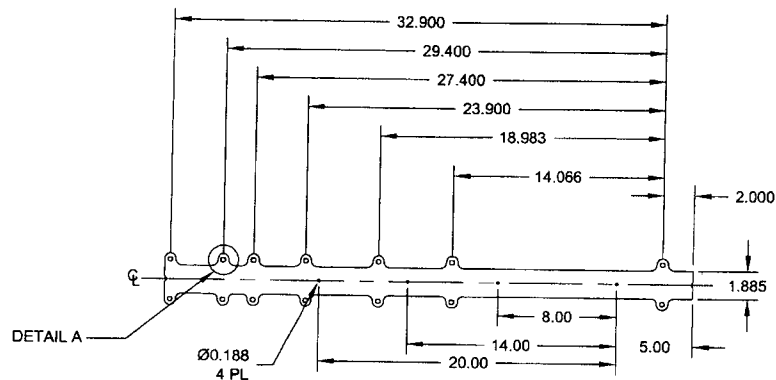
1.5139

m131060

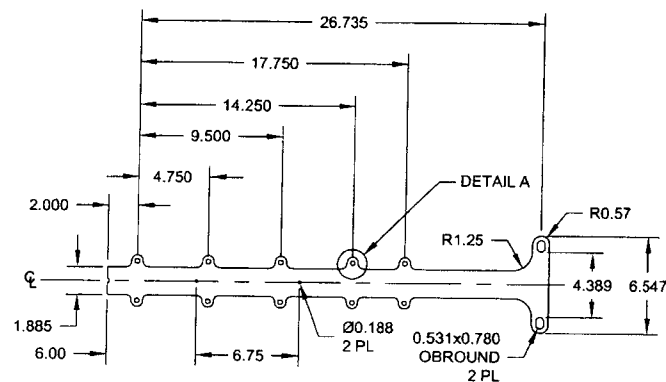
129.5984

131700

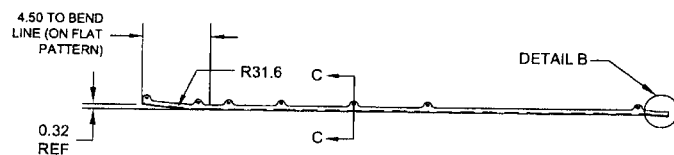
131700



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEXT (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

130534.MCS
1503-13

RELEASED
08.05.14

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN			BY	DATE
DRAWN	PH			
CHECKED	PH			
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

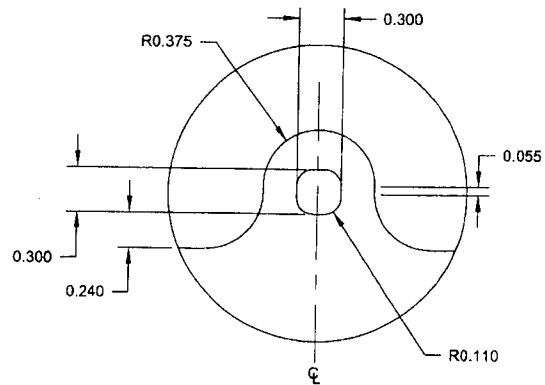
DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3793
REV. A
SHEET 1 OF 2
SCALE NTS

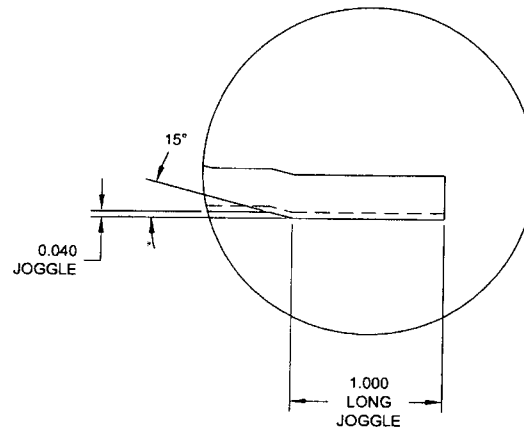
COPYRIGHT © 2008 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1

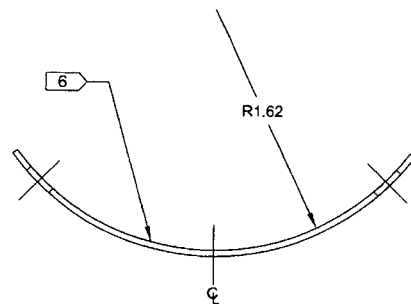
D



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-23

B

A

D

C

B

A

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1